

Work Order ID 57607

Friday, April 09, 2010 2:36:27 PM

Page 1

Item ID: D3953-19

Accept

Setup Start

Revision ID:

Stop

Item Name: Gas Spring Bracket

Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MF Date: 10-4-9 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3953	C
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100

0.00



Waterjet

FLOW CNC Waterjet

304 125

Memo

1-Cut as per Dwg D3953

Dwg Rev: CProg Rev: C

2-Deburr if necessary

=7 Deburr m.d 10/04/13

B10-4-12

(16)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

1810-4-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Required Date: 4/13/2010 Req'd Qty: 12.00

Reference:

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Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

130



Small Fab

Memo

0.00

Small Fab

1- CHAMFER HOLE AS PER DWG

2- DEBURR IF NECESSARY

0.00

0.00

0.00

140



QC

Memo

Quality Control

QC5- Inspect part completeness to step on W/O



(16)

9/30/04/14 (16)

(16)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Page 3

Item ID: D3953-19

Accept

Revision ID:

Item Name: Gas Spring Bracket

Start Date: 4/12/2010 Start Qty: 12.00

Required Date: 4/13/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location 101

0.00

Packaging

Memo

0.00

Packaging

10-4-1516kSP

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/04/19MF10-4-16.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, April 09, 2010 2:36:27 PM

Page 1

Work Order ID: 57607

Parent Item: D3953-19

Parent Item Name: Gas Spring Bracket

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
dwg revC DD 10.03.02 verified by:EC

IPP Rev:B as per

Start Date: 4/12/2010

Required Date: 4/13/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	33.8200	0.2274	31		



304/316 0.125 Sheet



1810-4-12

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT19

112663

33.82

33.82

112663

16

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

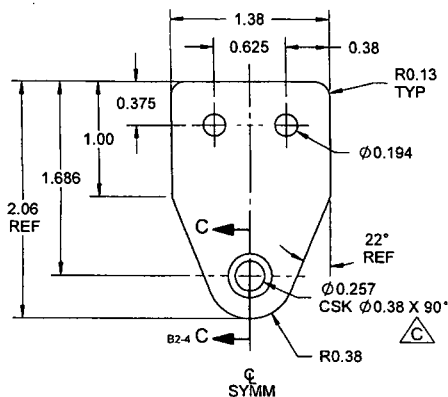
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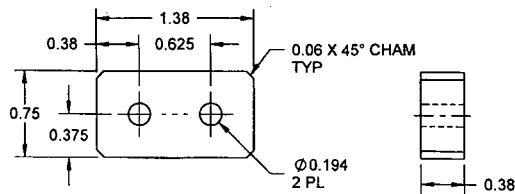
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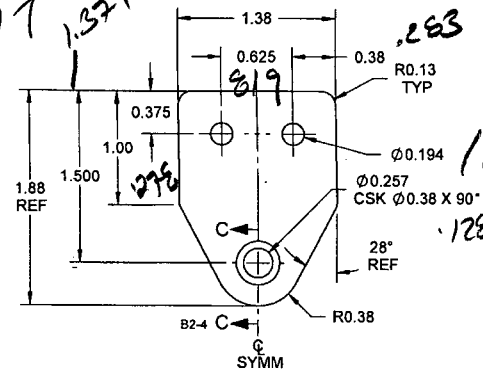
NOTE: Date & initial all entries



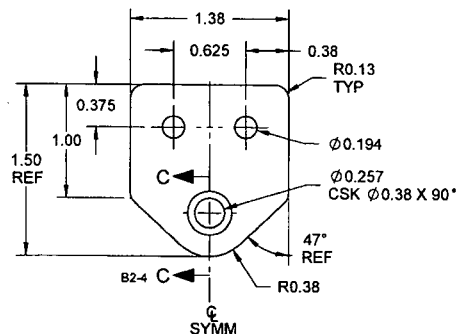
D3953-15 GAS SPRING BRACKET
(SPLIT LID)



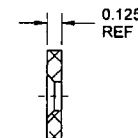
D3953-17 GAS SPRING SPACER
(SPLIT LID)



D3953-19 GAS SPRING BRACKET
(SQUARE BASKET)



D3953-21 GAS SPRING BRACKET
(SQUARE BASKET)



SECTION C-C

NOTES:

1) MATERIAL -15/-19/-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
-17: 0.10 lbs
-19: 0.07 lbs
-21: 0.06 lbs

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	AJS	DRAWING NO.	REV. C
DRAWN	JPH	D3953	SHEET 4 OF 4
CHECKED	GP	TITLE	SCALE
MFG. APPR.	B	GAS SPRING LID COMPONENTS	NTS
APPROVED	#	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DE APPR.	#	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.01.29		

RELEASED
2010-02-26

W/O:		WORK ORDER CHANGES					
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